

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021490**Date Inspected:** 25-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI observed ABF personnel fitting and tack welding cover plates into the Tower Grillage at Pier 7. The QAI noted that the cover plates are 25mm thick and that all the materials to be welded are grade 485W. The QAI was informed that only tack welding is approved at this time and that the welding procedures are still being developed. The QAI noted that the Quality Control (QC) Inspector Mike Johnson is monitoring the tack welding. The QAI noted that Rick Clayborn, ID 2773, is using shielded metal arc welding (SMAW) and localized preheating to make the overhead tack welds. The QAI noted that 3.2mm diameter, E9018-H4R electrodes are being used for the tack welding. The QAI noted that a Request for Information (RFI), # 2373 Revisions 0 and 1 have been approved and relate to the fit-up of the cover plates. The QAI noted that these plates are being modified per the approved RFIs and re-fit. The QAI noted that the tack welding is not completed and will continue tomorrow, 2.26.2010. The QAI was informed that there may be additional welders operating tomorrow and production welding might start on the partial joint penetration and complete joint penetration welds.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued reviewing and consolidating the information from welding report report packages to identify missing reports of inspections and general compliance to the contract requirements. The QAI continued generating a weld specific tracking list from the contractor's welding reports. The QAI began a cumulative review of all submitted and bootleg welding reports. During this process, the QAI identified additional missing reports / information that will be relayed to the contractor.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift, as noted above. The QAI relayed the status of weld report reviews and tower grillage welding to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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